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A METHOD AND APPARATUS FOR PRODUCING A LIQUID CRYSTAL DISPLAY

15 DEVICE

[Abstract]

PROBLEM TO BE SOLVED: To prevent the occurrence of a gap defect by crushing of elastic bodies interposed between surface plates and substrates in all directions.

20 SOLUTION: The manufacturing aperture for liquid crystal display device has the upper surface plate 1 and the lower surface plate 2 installed with the planar elastic materials 5 and is capable of bonding two sheets of the upper and lower substrates 3 and 4, at least one of which is subjected to coating application of sealing material and spraying of spacer particle 7 or forming of projection to each other by aligning

these substrates 3 and 4 in the state of vacuum attracting one sheet each to the upper surface plate 1 and the lower surface plate 2 and pressurizing the substrates 3 and 4 by means of both the surface plates 1 and 2. Attraction holes 51 of the elastic materials 5 are disposed to incline with the thickness direction of the elastic materials 5. As a result, the crushing direction of the elastic materials 5 is controlled and the pressurization onto the panel in bonding can be made uniform.

**[Claim(s)]**

[Claim 1] A method of producing a liquid crystal display device wherein the method comprises a process of spreading seal material for bonding two substrates and scattering spacer particles or generating projections for providing a gap  
5 between said substrates on at least one substrate of said substrates, a process of vacuum-absorbing said substrates respectively, a process of accomplishing an alignment of said substrates, and a process of bonding said substrates, wherein while vacuum-absorbing said substrates, any one substrate of said substrates is in contact with an elastic body and vacuum-absorbed by absorption holes of said  
10 elastic body that is inclined to a thickness direction of said elastic body.

[Claim 2] The method of Claim 1, wherein said absorption holes of said elastic body are inclined in the same direction.

[Claim 3] The method of Claim 1, wherein said absorption holes of said elastic body are inclined more than 3° to the thickness direction of said elastic body.

15 [Claim 4] A method of producing a liquid crystal display device wherein the method comprises a process of spreading seal material for bonding two substrates and scattering spacer particles or generating projections for providing a gap between said two substrates on at least one substrate of said substrates, a process

of vacuum-absorbing said substrates respectively, a process of maintaining degrees of vacuum within an environment including said substrates lower than those at vacuum-absorption of said substrate, a process of accomplishing an alignment of said substrates while maintaining a constant distance between said  
5 substrates, and a process of bonding said substrates by pressurizing said substrates and pressing said seal material, characterized in upon vacuum-absorbing said two substrates, any one substrate of said substrates is contacted with an elastic body and vacuum-absorbed by absorption holes of said elastic body that is inclined to a thickness direction of said elastic body.

10 [Claim 5] The method of Claim 4, wherein said absorption holes of said elastic body are inclined in the same direction.

[Claim 6] The method of Claim 4, wherein said absorption holes of said elastic body are inclined more than 3° to the thickness direction of said elastic body.

[Claim 7] An apparatus for producing a liquid crystal display device wherein  
15 the apparatus includes an upper surface plate and a lower surface plate with a plate-shaped elastic body; each of two substrates is vacuum-absorbed on said upper surface plate and said lower surface plate respectively - on at least one substrate of said substrates, seal materials are spreaded and spacer particles are scattered or projections are generated; an alignment of said substrates is

accomplished; and said substrates are bonded by pressurizing said substrates by said upper and lower surface plates, characterized in absorption holes of said elastic body are inclined to a thickness direction of said elastic body.

[Claim 8]      The method of Claim 7, wherein said absorption holes of said elastic  
5    body are inclined in the same direction.

[Claim 9]      The apparatus of Claim 7, wherein said absorption holes of said elastic body are inclined more than 3° to the thickness direction of the elastic body.

[Claim 10]     An apparatus for producing a liquid crystal display device wherein the apparatus includes a upper surface plate, a lower surface plate with a plate-  
10    shaped elastic body, and a chamber in which said upper surface plate and said lower surface plate are located; each of two substrates is vacuum-absorbed on said upper surface plate and said lower surface plate respectively - on at least one substrate of said substrates, seal materials are spreaded and spacer particles are scattered or projections are generated; an alignment of said substrates are  
15    accomplished while maintaining a constant distance between said substrates under the condition that said chamber are maintained at lower degrees of vacuum than those at vacuum-absorption of said substrates; and said substrates are bonded by pressurizing said substrates by said two surface plate and pressing said seal materials, characterized in absorption holes of the elastic body are inclined to a

direction of thickness of said elastic body.

[Claim 11] The method of Claim 10, wherein said absorption holes of said elastic body are inclined in the same direction.

[Claim 12] An apparatus of Claim 10, wherein said absorption holes of said  
5 elastic body are inclined more than  $3^{\circ}$  over the direction of thickness of said elastic body.

**[Title of the Invention]**

A METHOD AND APPARATUS FOR PRODUCING A LIQUID CRYSTAL DISPLAY  
DEVICE

**[Detailed Description of the Invention]**

5   **[Field of the Invention]**

        This invention relates to a method and apparatus for producing a liquid  
crystal display device.

**[Description of the Prior Art]**

        As a method of producing liquid crystal display device, there are used two  
10   methods as follows: Firstly, the first method is a vacuum injection method. As  
shown in figure 6, on any one substrate of two substrates 3, 4, two substrates 3, 4  
are bonded and seal materials 6 for sealing liquid crystal materials are patterned  
with one to several cracks. Further, spacer particles 7 or projections are generated  
for maintaining cell gap of a predetermined value on any one substrate of two  
15   substrates 3, 4. These two substrates 3, 4 are vacuum-absorbed on an upper  
surface plate and a lower surface respectively and bonded under the air pressure,  
and thereafter the seal materials 6 are cured, thereby to create an empty cell. After  
liquid crystal materials are injected from the one to several cracks (injection hole) of

seal materials within the vacuum chamber in the empty cell, the injection holes are sealed using the seal materials. As such, the liquid crystal display device is assembled.

The second method is a dropping method. On any one substrate of two  
5 substrates, two substrates are bonded and seal materials for sealing liquid crystal materials are patterned without joints. Further, spacer particles and projections are generated for maintaining cell gap of predetermined value on any one substrate of two substrates. Any amounts of liquid crystal materials are dropped on any one substrate of two substrates. These two substrates are vacuum-absorbed on the  
10 upper and lower surface plates and bonded within the vacuum-absorbed chamber, and then the seal materials are cured. As such, liquid crystal display device is assembled.

In terms of cell gap that is necessary in the liquid crystal display device, it is generally less than  $\pm 0.3 \mu\text{m}$  in the case of TN liquid crystal display device and less  
15 than  $\pm 0.05 \mu\text{m}$  in the case of STN liquid crystal display device, whereas the plane processing accuracy of the upper and lower surface plate is only  $\pm 20 \mu\text{m}$ . Therefore, with respect to a method of bonding a liquid crystal display device in accordance with the injection method, since it can not pressurize the upper and



lower substrates uniformly, it needs to pressurize the upper and lower substrates uniformly using a pressurize and to press a seal resin at predetermined amounts. By providing an elastic body between the lower surface plate and the lower substrate, it is possible to pressurize the substrates while pressing the seal resin at  
5 the predetermined amounts during bonding process.

At this time, because the upper and lower substrates must be held by vacuum-absorbing on the upper and lower surface plate not to disorder an alignment thereof, it is necessary to hollow a vacuum absorption holes in the elastic body that is located between the lower substrate and the lower surface plate.

10 [Problem(s) to be Solved by the Invention]

However, an inclination of the absorption holes of the elastic body to the surface of the elastic body is irregular, the elastic body is pressurized in every directions upon bonding, and subsequently a pressure applied to panel is irregular, with the result that it induces undesirable cell gaps in a panel after assembling  
15 process, and leads to deterioration of a panel quality accordingly.

Therefore, the object of this invention is to provide a method and apparatus for producing a liquid crystal display device that can avoid undesirable cell gaps occurring as a result that the elastic body interposed between the surface plate and the substrate are pressurized in every direction.

[Means for Solving the Problem]

To resolve the above-mentioned problems, a method of producing a liquid crystal display device disclosed in claim 1 comprises a process of spreading seal materials for bonding two substrates and scattering spacer particles or generating  
5 projections for providing a gap between the substrates on at least one substrate of the substrates, a process of vacuum-absorbing the substrates respectively, a process of accomplishing an alignment of the substrates, and a process of bonding the substrates, and when vacuum-absorbing the substrates, any one substrate of the substrates is contacted to an elastic body and vacuum-absorbed by absorption  
10 holes of the elastic body that is inclined to a thickness direction of the elastic body.

As such, with respect to an injection method which spreads seal materials for bonding two substrates and scatters spacer particles or generates projections for providing a gap between two substrates on at least one substrate of two substrates, and bonds the substrates to create a cell gap, since any one substrate  
15 of two substrates is contacted to the elastic body and is vacuum-absorbed by absorption holes of an elastic body that is inclined to thickness direction of the elastic body, it is possible to control the direction in which the elastic body is pressed and to pressurize into panel uniformly upon bonding. That is, because the elastic body is pressed in the inclined direction of the absorption holes, it is possible

to control the pressed direction of the elastic body in advance so that pressurization into panel will be uniform, thereby to prevent gap deterioration from occurring in the panel after assembling process.

According to a method of producing the liquid crystal display device of claim  
5 1 disclosed in claim 2, the absorption holes of the elastic body are inclined in the same direction. As such, because the absorption holes are inclined in same direction, the directions that the absorption holes of the elastic body are pressed will be uniform.

According to a method of producing the liquid crystal display device of claim  
10 1 disclosed in claim 3, the absorption holes of the elastic body are inclined more than 3° to the thickness direction of the elastic body. As such, because the absorption holes of the elastic body are inclined more than 3 degrees, it is ensured to control the direction that the elastic body is pressed, which results in improving cell gap deterioration.

15 A method of producing a liquid crystal display device disclosed in claim 4 comprises a process of spreading seal materials for bonding two substrates and scattering spacer particles or generating projections for providing a gap between the two substrates on at least one substrate of the substrates, a process of vacuum-absorbing the substrates respectively, a process of maintaining degrees of

vacuum within an environment including the substrates lower than those at vacuum-absorption of the substrate, a process of accomplishing an alignment of the substrates while maintaining a constant distance between the substrates, and a process of bonding the substrates by pressurizing the substrates and pressing the seal materials, and when vacuum-absorbing the two substrates, any one substrate of the substrates is contacted with an elastic body and vacuum-absorbed by absorption holes of the elastic body that is inclined to a thickness direction of the elastic body.

As such, with respect to a dropping method which spreads seal materials for bonding two substrates and scatters spacer particles or generates projections for providing a gap between two substrates on at least one substrate, and vacuum-absorbs the two substrates respectively, since any one substrate of two substrates is contacted to the elastic body and is vacuum-absorbed by absorption holes of the elastic body that is inclined to thickness direction of the elastic body, it is possible to control the direction in which the elastic body is pressed and to pressurize into a panel uniformly upon bonding. That is, because the elastic body is pressed in the inclined direction of the absorption holes, it is possible to control the pressed direction of the elastic body in advance so that pressurization into panel will be uniform, thereby to prevent gap deterioration from occurring in the panel after assembling process.

According to a method of producing the liquid crystal display device of claim 4 disclosed in claim 5, the absorption holes of the elastic body are inclined in the same direction. As such, because the absorption holes are inclined in same direction, the directions that the absorption holes of the elastic body are pressed  
5 will be uniform.

According to a method of producing the liquid crystal display device of claim 4 disclosed in claim 6, the absorption holes of the elastic body are inclined more than  $3^\circ$  to the thickness direction of the elastic body. As such, because the absorption holes of the elastic body are inclined more than 3 degrees, it is ensured  
10 to control the direction that the elastic body is pressed, which results in improving cell gap deterioration.

An apparatus for producing a liquid crystal display device disclosed in claim 7 includes an upper surface plate and a lower surface plate with a plate-shaped elastic body; each of two substrates is vacuum-absorbed on the upper surface  
15 plate and the lower surface plate respectively - on at least one substrate of the substrates, seal materials are spreaded and spacer particles are scattered or projections are generated; an alignment of the substrates is accomplished; and the substrates are boned by pressurizing the substrates by the upper and lower surface plates, and absorption holes of the elastic body are inclined to a thickness direction

of the elastic body.

Such as, with respect to a injection method wherein the apparatus includes a upper surface plate and a lower surface plate with plate-shaped elastic body, seal materials are spreaded and spacer particles are scattered or projections are  
5 generated on at least one substrate of two substrates, the substrates are vacuum-absorbed on the upper and lower surface plates respectively, and the substrates are bonded, since the absorption holes of the elastic body are inclined to a thickness of the elastic body, it is possible to control the direction that the elastic body is pressed, and to pressurize into a panel uniformly upon bonding.

10 According to an apparatus for producing the liquid crystal display device of claim 7 disclosed in claim 8, the absorption holes of the elastic body are inclined in the same direction. As such, because the absorption holes are inclined in same direction, the directions that the absorption holes of the elastic body are pressed will be uniform.

15 According to an apparatus for producing the liquid crystal display device of claim 7 disclosed in claim 9, the absorption holes of the elastic body are inclined more than 3° to the thickness direction of the elastic body. As such, because the absorption holes of the elastic body are inclined more than 3 degrees, it is ensured to control the direction that the elastic body is pressed, which results in improving

cell gap deterioration.

An apparatus for producing a liquid crystal display device disclosed in claim 10 includes a upper surface plate, a lower surface plate with a plate-shaped elastic body, and a chamber in which the upper surface plate and the lower surface plate are located; each of two substrates is vacuum-absorbed on the upper surface plate and the lower surface plate respectively - on at least one substrate of the substrates, seal materials are spreaded and spacer particles are scattered or projections are generated; an alignment of the substrates are accomplished while maintaining a constant distance between the substrates under the condition that the chamber are maintained at lower degrees of vacuum than those at vacuum-absorption of the substrates; and the substrates are bonded by pressurizing the substrates by the two surface plate and pressing the seal materials, and absorption holes of the elastic body are inclined to a thickness direction of the elastic body.

Such as, with respect to a dropping method wherein the apparatus includes a upper surface plate, a lower surface plate with plate-shaped elastic body, and a chamber in which the upper surface plate and the lower surface plate are located, seal materials are spreaded and spacer particles are scattered or projections are generated on at least one substrate of two substrates, the substrates are vacuum-absorbed on the upper and lower surface plates respectively, and these substrates

are bonded, it is possible to control the direction that the elastic body is pressed, and to pressurize into a panel uniformly upon bonding.

According to an apparatus for producing the liquid crystal display device of claim 10 disclosed in claim 11, the absorption holes of the elastic body are inclined  
5 in the same direction. As such, because the absorption holes are inclined in same direction, the directions that the absorption holes of the elastic body are pressed will be uniform.

According to an apparatus for producing the liquid crystal display device of claim 10 disclosed in claim 12, the absorption holes of the elastic body are inclined  
10 more than  $3^\circ$  to the thickness direction of the elastic body. As such, because the absorption holes of the elastic body are inclined more than 3 degrees, it is ensured to control the direction that the elastic body is pressed, which results in improving cell gap deterioration.

#### [Embodiment of the Invention]

15 The first embodiment of this invention will be described with reference to Figure 1 to figure 4. Figure 1 is a schematic diagram of an apparatus for producing a liquid crystal display device according to the first embodiment of this invention, Figure 2 is a top plane view that illustrates an elastic



body according to this embodiment of the invention, and Figure 3 is a top plane view that illustrates an lower surface plate according to this embodiment of the invention.

As shown in Figure 1 to Figure 3, the apparatus for producing the liquid  
5 crystal display device includes a upper surface 1 and a lower surface 2 with plate-shaped elastic body 5, and accomplishes an alignment of two substrates 3, 4 under the condition that they are vacuum-absorbed on the upper surface plate 1 and the lower surface plate 2 respectively, and bonds two substrates by pressurizing both of the surface plates 1, 2, - on at least one substrate of the two substrates, a seal  
10 materials 6 are spreaded and spacer particles 7 are scattered. Further, the absorption holes 51 of the elastic body 5 are inclined to a thickness direction of the elastic body. At this time, the lower surface plate 2 is provided with absorption grooves that communicate with the absorption holes.

Subsequently, the method of producing the liquid crystal display device will  
15 be described. First, this method prepares an array substrate and a color filter substrate that are formed typically, and each substrate goes through cleaning process, forming process of alignment layer made of polyimide, and prescribed rubbing process.

Next, spacer particles 7 which are made of resin and have particle diameter

of  $4.5\mu\text{m}$  are spreaded on the side of the array substrate, whereas seal resin 6 which is mixed with glass fiber of diameter  $5.5\mu\text{m}$  is patterned using screen printing on the side of the color filter substrate. At this occasion, the color filter substrate is patterned with injection hole.

- 5           Using such array substrate and color filter substrate, a bonding process is performed as follows.

The bonding device performs the bonding process by inserting elastic body 5 between the lower surface plate 2 and the lower substrate 4. The elastic body 5 is made of silicon rubber materials.

- 10           The color filter substrate is vacuum-absorbed on the lower surface plate 2 with the elastic body 5 interposed therebetween and the array substrate are vacuum-absorbed on the upper surface plate 1 respectively, an alignment and bonding processes are accomplished for the upper and lower substrates 3, 4, and seal resin 6 is sufficiently pressed at 1.5 ton between the upper and lower surface
- 15   plate 1, 2. As shown in figure 4(a), set a shows that absorption holes of the elastic body 5 hollows vertically (a thickness direction of elastic body) to surface of the elastic body, and as shown in figure 4(b) to (d), set b, c, and d show they hollow inclined 2, 3, and 4 degrees to a thickness direction of the elastic body, respectively.

Subsequently, after the set a, set b, set c, and set d that finish bonding are extracted from the bonding device, the seal resin 6 is cured by UV irradiation.

After cutting circumferential parts of the substrates in these sets a, b, and c that finish bonding, the liquid crystal display device is provided by filling liquid  
5 crystal material by vacuum injection method and sealing the injection hole.

Second embodiment will be now described with reference to Figure 5. Figure 5 is a schematic diagram illustrating an apparatus for producing a liquid crystal display device according to the second embodiment of this invention.

As shown in figure 5, the apparatus for producing the liquid crystal display  
10 device includes a upper surface plate 1, a lower surface plate 2 with plate-shaped elastic body 5, and a chamber 9 in which the upper surface plate 1 and the lower surface plate 2 are located, and accomplishes an alignment of two substrates 3, 4 while maintaining a constant distance therebetween under the condition that they are vacuum-absorbed on the upper surface plate 1 and the lower surface plate 2  
15 respectively and the chamber 9 is maintained with a lower degrees of vacuum than those at vacuum-absorbing of the substrate, and bonds two substrates by pressurizing both the surface plates 1, 2 and pressing seal materials 6, - on at least one substrate of two substrates, seal materials 6 are spreaded and spacer particles 7 are scattered. Further, the absorption holes 51 of the elastic body are inclined to

a thickness direction of the elastic body.

Subsequently, the method of producing the liquid crystal display device will be described. First, this method prepares an array substrate and a color filter substrate that are formed typically, and each substrate goes through cleaning  
5 process, forming process of alignment layer made of polyimidee, and prescribed rubbing process like the first embodiment.

Next, spacer particles 7 which are made of resin and have particle diameters of  $4.5\mu\text{m}$  are spreaded on the side of the array substrate, whereas UV curing seal resin 6 which is mixed with glass fiber of diameter  $5.5\mu\text{m}$  is patterned  
10 using screen printing on the side of the color filter substrate. At this time, the color filter substrate is patterned without injection hole.

Using such array substrate and color substrate, bonding process is performed as follows.

The bonding process is performed after dropping liquid crystal materials 8  
15 on the color filter substrate. The bonding device performs the bonding process by inserting the elastic body 5 between the lower surface plate 2 and the lower substrate 4 like the first embodiment.

The color filter substrate on which liquid crystals are dropped in advance is vacuum-absorbed on the lower surface plate 2 with elastic body 5 interposed

therebetween and the array substrate are vacuum-absorbed on the upper surface plate 1 respectively, and this vacuum-absorption is performed until the degrees of vacuum within the chamber 9 is  $0.5 \times 133.322$  to  $1.0 \times 133.322$  Pa (0.5 to 1.0 torr). At this occasion, the degree of vacuum at this vacuum-absorption by the upper and lower surface plates 1, 2 is less than  $0.1 \times 133.322$  Pa (0.1 torr).

After an alignment of the upper and lower substrates 3, 4 is accomplished while maintaining above degrees of vacuum within the vacuum chamber 9, the substrates are bonded and seal resin 6 is sufficiently pressed at 1.5 ton between the upper and lower surface plate 1, 2. At this occasion, set e shows that the absorption holes of the elastic body 5 hollows vertically to surface of elastic body, and set f, set g, and set j show that they hollow inclined 2, 3, and 4 degrees to the thickness direction of the elastic body, respectively. Shapes of the elastic body 4 in the set e to the set h correspond to Figure 4(a) to 4(d).

Subsequently, after the set e, the set f, the set g, and the set h that finish bonding are extracted from a bonding device, a liquid crystal display device is provided by curing the seal resin 6 by UV irradiation and cutting away circumferential parts of the substrates.

As a comparative example, an array substrate and a color filter substrate are generated like the first embodiment, but bonding is performed as follows.

That is, bonding process in the set i is performed using prior art method. As shown in Figure 6, after the color filter substrate is vacuum-absorbed on the lower surface plate 2 and the array substrate is vacuum-absorbed on the upper surface plate 1, an alignment of the upper and lower substrates 3, 4 (array substrate, color film substrate) is accomplished and then they are bonded.

Subsequently, after the substrate set i that finishes bonding is extracted from the bonding device, seal resin 6 is pressed by performing vacuum packing, and then cured by UV irradiation.

A measurements (100 points in plane) for cell gaps of the liquid crystal display device in such set a to set i are performed. Further, visual measurements for display uniformity are performed by mounting circumferential circuits and performing a panel display. The results are shown in table 1.

[Table 1]

As can be understood from the table 1, it is possible to improve cell gap deterioration if absorption holes of the elastic body hollow inclined more than 3 degrees to a thickness direction of the elastic body.

[Effect of the Invention]

According to the method of producing the liquid crystal display device disclosed in Claim 1 of this invention, with respect to an injection method which

spreads seal materials for bonding two substrates and scatters spacer particles or generates projections for providing a gap between two substrates on at least one substrate of two substrates, and bonds the substrates to create a cell gap, since any one substrate of two substrates is contacted to the elastic body and is vacuum-  
5 absorbed by absorption holes of an elastic body that is inclined to thickness direction of the elastic body, it is possible to control the direction in which the elastic body is pressed and to pressurize into panel uniformly upon bonding. That is, because the elastic body is pressed in the inclined direction of the absorption holes, it is possible to control the pressed direction of the elastic body in advance so that  
10 pressurization into panel will be uniform, thereby to prevent gap deterioration from occurring in the panel after assembling process. As a result, the invention can provide liquid crystal display device of high quality having uniform cell gap.

According to Claim 2, because the absorption holes are inclined in same direction, the directions that the absorption holes of the elastic body are pressed  
15 will be uniform.

According to Claim 3, because the absorption holes of the elastic body are inclined more than 3 degrees, it is ensured to control the direction that the elastic body is pressed.

According to the method of producing the liquid crystal display device

disclosed in Claim 4 of this invention, with respect to a dropping method which spreads seal materials for bonding two substrates and scatters spacer particles or generates projections for providing a gap between two substrates on at least one substrate, and vacuum-absorbs the two substrates respectively, since any one  
5 substrate of two substrates is contacted to the elastic body and is vacuum-absorbed by absorption holes of the elastic body that is inclined to thickness direction of the elastic body, it is possible to control the direction in which the elastic body is pressed and to pressurize into a panel uniformly upon bonding. That is, because the elastic body is pressed in the inclined direction of the absorption holes,  
10 it is possible to control the pressed direction of the elastic body in advance so that pressurization into panel will be uniform, thereby to prevent gap deterioration from occurring in the panel after assembling process. As a result, the invention can provide liquid crystal display device of high quality having uniform cell gaps.

According to Claim 5, because the absorption holes are inclined in same  
15 direction, the directions that the absorption holes of the elastic body are pressed will be uniform.

According to Claim 6, because the absorption holes of the elastic body are inclined more than 3 degrees, it is ensured to control the direction that the elastic body is pressed.



According to the apparatus of producing the liquid crystal display device disclosed in Claim 7 of this invention, with respect to a injection method wherein the apparatus includes a upper surface plate and a lower surface plate with plate-shaped elastic body, seal materials are spreaded and spacer particles are scattered  
5 or projections are generated on at least one substrate of two substrates, the substrates are vacuum-absorbed on the upper and lower surface plates respectively, and the substrates are bonded, since the absorption holes of the elastic body are inclined to a thickness of the elastic body, it is possible to control the direction that the elastic body is pressed, and to pressurize into a panel  
10 uniformly upon bonding. As a result, this invention can provide liquid crystal display device of high quality having uniform cell gaps.

According to Claim 8, because the absorption holes are inclined in same direction, the directions that the absorption holes of the elastic body are pressed will be uniform.

15 According to Claim 9, because the absorption holes of the elastic body are inclined more than 3 degrees, it is ensured to control the direction that the elastic body is pressed.

According to the apparatus of producing the liquid crystal display device disclosed in Claim 10 of this invention, with respect to a dropping method wherein

the apparatus includes a upper surface plate, a lower surface plate with plate-shaped elastic body, and a chamber in which the upper surface plate and the lower surface plate are located, seal materials are spreaded and spacer particles are scattered or projections are generated on at least one substrate of two substrates,  
5 the substrates are vacuum-absorbed on the upper and lower surface plates respectively, and these substrates are bonded, it is possible to control the direction that the elastic body is pressed, and to pressurize into a panel uniformly upon bonding, with the result that the invention can provide liquid crystal display device of high quality having uniform cell gap.

10 According to Claim 11, because the absorption holes are inclined in same direction, the directions that the absorption holes of the elastic body are pressed will be uniform.

According to Claim 12, because the absorption holes of the elastic body are inclined more than 3 degrees, it is ensured to control the direction that the elastic  
15 body is pressed.

**[Description of Drawings]**

Figure 1 is a schematic diagram of an apparatus for producing a liquid crystal display device according to the first embodiment of the invention.

Figure 2 is a top plane view that schematically illustrates an elastic body  
5 according to this embodiment of the invention.

Figure 3 is a top plane view that schematically illustrates a lower surface plate according to this embodiment of the invention.

Figure 4 is a schematic diagram showing each absorption hole of the elastic body for liquid crystal display device in various degrees

10 Figure 5 is a schematic diagram illustrating an apparatus for producing a liquid crystal display device according to the second embodiment of this invention.

Figure 6 is a schematic diagram illustrating the case that injection method is applied to method of producing a liquid crystal display device according to prior art.